

**Work Order ID 69369**

Tuesday, May 10, 2011 12:24:43 PM

Ship Friday Page 1

Item ID: DSI 9500-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 5/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: MFDate: 11-05-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

DSI 9500

A

100

0.00



DC

Document Control

Memo

Photocopy bluefile & type labels per PPP DSI9500-011  
CHG001

0.00

8/11/13

Adm BG 11-5-12

110

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

11/10/12 (Y)

120

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

8/11/13

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69369**

Page 2

Tuesday, May 10, 2011 12:24:43 PM

Item ID: DSI 9500-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 5/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Packaging								
Packaging	Memo	0.00							
	Identify and pack for shipping as per PPP DSI9500-011								
	Location: _____								
	PPP rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
	QC								
Quality Control	Memo	0.00							

U 1005.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 10, 2011 12:24:39 PM

Page 1

Work Order ID: 69369

Parent Item: DSI 9500-011

Parent Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 5/10/2011

Required Date: 5/13/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A new issue DD 10.03.01 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2731-7		Manufactured	No			110	Each	71.0000	2	8			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Mounting Lug

Location

Loc Qty

Loc Code

ST470

71

62929

39

66427

32

D2732-030		Manufactured	No			110	Each	12.0000	8	32			
-----------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--



Rubber Cushion

Location

Loc Qty

Loc Code

ST410

12

56516

10

65395

2

D3394-043		Manufactured	No			110	Each	92.0000	2	8			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Lug Assembly

Location

Loc Qty

Loc Code

ST475

92

62930

28

62976

30

66429

34

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Tuesday, May 10, 2011 12:24:39 PM

Page 2

Work Order ID: 69369



Parent Item: DSI 9500-011



Parent Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 5/10/2011

Required Date: 5/13/2011

Start Qty: 4.00

Required Qty: 4.00

D4064-041

Manufactured No

110 Each

29.0000



Mounting Lug



4

Location

Loc Qty

Loc Code

ST462

18

62977

18

ST464

11

58980

10

58985

1

62977

58980

AN4C13A

Purchased No

110 Each

0.0000



BOLT

AN4C14A

Purchased No

110 Each

70.0000



Bolt



16

1117688

Location

Loc Qty

Loc Code

ST357

70

117366

40

117441

30

1117441

AN4C15A

Purchased No

110 Each

87.0000



Bolt



16

Location

Loc Qty

Loc Code

ST358

87

115936

27

117441

60

115936

AN960C416

NAS1149C0463  
R

Purchased No

110 Each

0.0000



washer



16

64

1115358

Tuesday, May 10, 2011 12:24:39 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, May 10, 2011 12:24:40 PM

Page 3

Work Order ID: 69369



Parent Item: DSI 9500-011



Parent Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 5/10/2011

Required Date: 5/13/2011

Start Qty: 4.00

Required Qty: 4.00

AN960C416L *NAS114900432R* Purchased No

110 Each

0.0000

8

32



WASHER

NAS1515H4L Purchased No

110 Each

454.0000

24

96



WASHER

## Location

## Loc Qty

## Loc Code

FG

40

103691

40

ST266

20

114265

20

ST277

394

117363

394

MS21043-4 Purchased No

110 Each

1,446.000

12

48



Nut

## Location

## Loc Qty

## Loc Code

FG

40

104603

40

ST300

600

117423

600

ST301

806

116188

6

116549

300

117601

500

116549

Tuesday, May 10, 2011 12:24:40 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-628 REV. F

REF FAA STC: SA00500SE  
REF TCCA STC: SH98-14  
REF EASA STC EASA.IM.R.S.01339

**REFERENCE ONLY**

6

**PURPOSE:**

UNMODIFIED D206-628-013/-014 STEP INSTALLATIONS AT CHANGE 005 (OR EARLIER) WILL NOT INSTALL AT THE 18.50" HEIGHT REQUIRED FOR COMPATIBILITY WITH APICAL TRI-BAG FLOATS.

**CHANGE:**

D206-628-013/-014 STEP INSTALLATIONS AT CHANGE 006 (OR LATER) CONTAIN NEW MOUNTING LUGS FOR COMPATIBILITY WITH APICAL FLOATS.

CONTRARY TO INSTALLATION INSTRUCTIONS IIN-D206-628, FOR COMPATIBILITY WITH APICAL TRI-BAG FLOATS, THE D206-628-013/-014 STEP INSTALLATIONS SHOULD BE INSTALLED AT A HEIGHT OF 17.25" PER FIGURE 1 OF THIS SERVICE INSTRUCTION.

WHEN INSTALLING THE MOUNTING LUGS, IT IS ACCEPTABLE TO USE LONGER/SHORTER AN4C BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960C416/416L WASHERS UNDER THE BOLT HEADS TO ENSURE 1.5 TO 4 THREADS IN SAFETY.

PARTS LIST OF SECTION 5.2 (PG. 12) OF IIN-D206-628-013/-014 REV. F IS AMENDED AS FOLLOWS:

QTY -013	QTY -014	QTY -023	QTY -024	QTY -033	QTY -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INSTALLATION, LH
	X					D206-628-014	206 A/B FLOAT STEP INSTALLATION, RH

WAS:

2	2					D2731-3	MOUNTING LUG
2	2					D2731-7	MOUNTING LUG
2	2					D3394-041	MOUNTING LUG
2	2					D3394-043	MOUNTING LUG
16	16					AN960C416L	WASHER

IS:

4	4					D2731-7	MOUNTING LUG
4	4					D3394-043	MOUNTING LUG
1	1					D4064-041	MOUNTING LUG (NEW)
1	1					*D4064-1	LUG
2	2					*MS35489-93	GROMMET
16	16					AN960C416	WASHER

\* DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

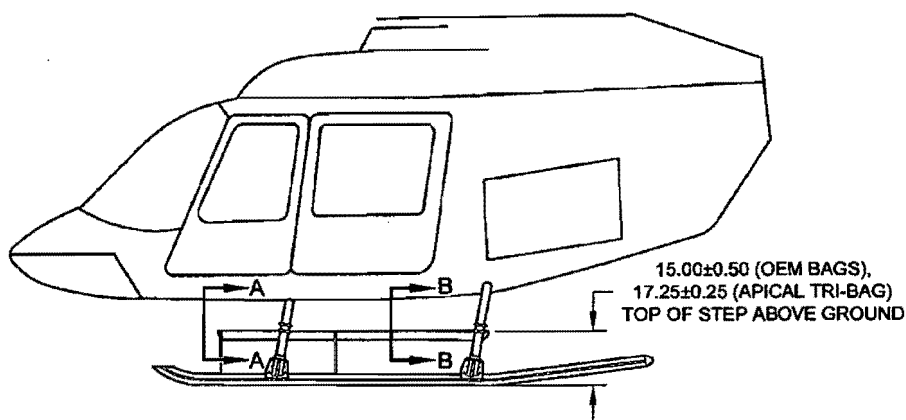
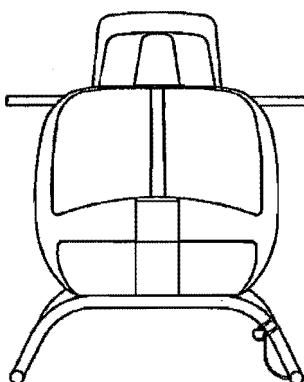
A	NEW ISSUE	CP	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>QP</i>	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	<i>QP</i>		
CHECKED	<i>3</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>N/A</i>	DSI 9500	SHEET 1 OF 4
APPROVED	<i>H</i>	TITLE	SCALE
DE APPR.	<i>H</i>	MOUNTING LUG CHANGE	NTS
DATE	10.01.29	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



THE DSI-9500-011 LUG UPGRADE KIT IS AVAILABLE TO UPDATE EXISTING D206-628-013/-014 STEPS TO CHANGE 006. THE UPGRADE KIT INCLUDES ADDITIONAL LUGS FOR STEPS INSTALLED WITH APICAL TRI-BAG FLOATS (AT 17.25" HEIGHT). EXISTING D206-628-013/-014 STEPS INSTALLED WITH OEM FLOATS (AT 15.00" HEIGHT) DO NOT REQUIRE THE KIT. THE UPGRADE KIT SHOULD BE INSTALLED PER THIS SERVICE INSTRUCTION AND IIN-D206-628 REV. F.

QTY -011	Part Number	Description
X	DSI-9500-011	LUG UPGRADE KIT, 206 A/B FLOAT STEP
12	D2731-7	MOUNTING LUG (REPLACES D2731-3 MOUNTING LUG)
8	D2732-030	RUBBER CUSHION
2	D3394-043	MOUNTING LUG (REPLACES D3394-041 MOUNTING LUG)
1	D4064-041	MOUNTING LUG (REPLACES ONE D3394-043 FOR APICAL TRI-BAG FLOAT COMPATIBLE INSTALL)
4	AN4C13A	BOLT
4	AN4C14A	BOLT
4	AN4C15A	BOLT
16	AN960C416	WASHER
8	AN960C416L	WASHER
24	NAS1515H4L	WASHER
12	MS21043-4	NUT

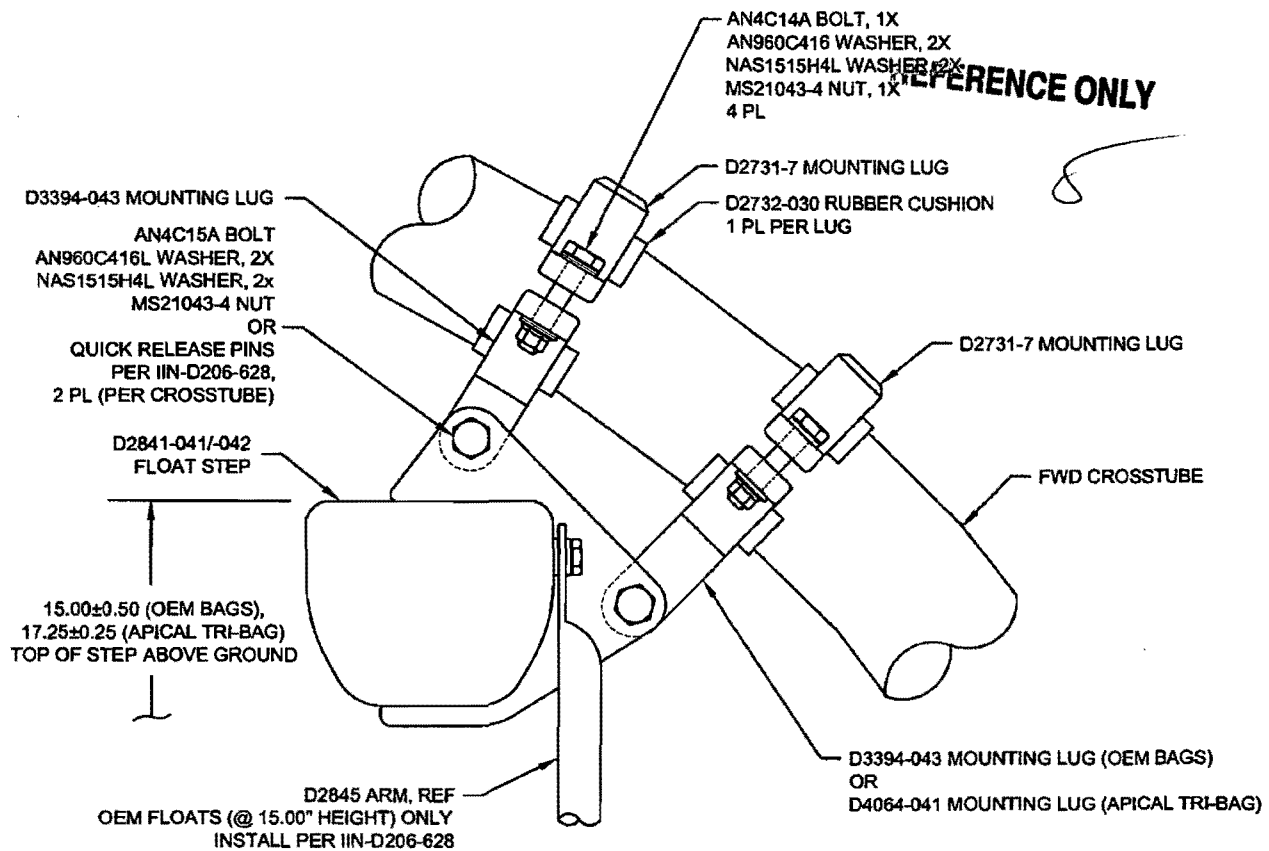
REFERENCE ONLY



**FIGURE 1**  
D206-628-013 (SHOWN) / -014 (OPPOSITE)  
206 A/B FLOAT STEP INSTALLATION

DESIGN	97	<b>DART AEROSPACE USA, INC</b>	
DRAWN	97	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9500	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG CHANGE	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



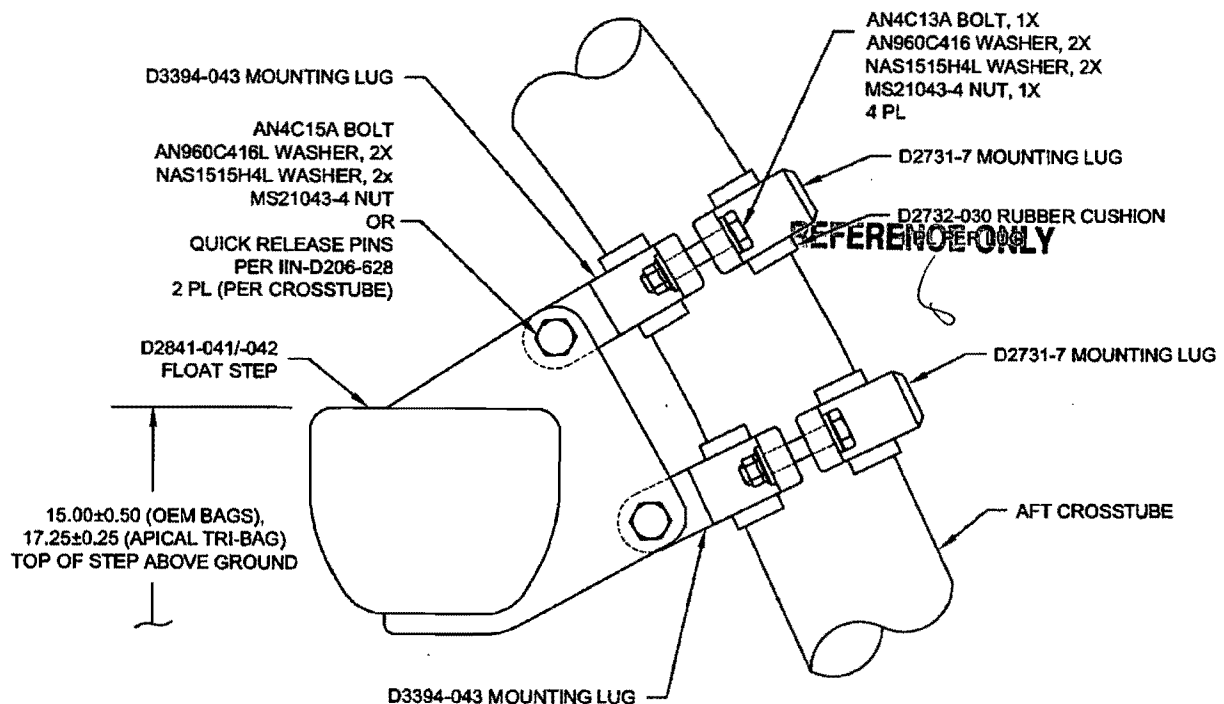


**SECTION A-A**  
FWD CROSSTUBE CLAMPING DETAIL

DESIGN		<b>DART AEROSPACE USA, INC</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9500	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG CHANGE	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	







**SECTION B-B**  
AFT CROSSTUBE CLAMPING DETAIL

DESIGN	99	<b>DART AEROSPACE USA, INC</b>	
DRAWN	99	PORT HADLOCK, WA	
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9500	SHEET 4 OF 4
APPROVED	99	TITLE	SCALE
DE APPR.	99	MOUNTING LUG CHANGE	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

